

Date: Monday, 3/13/2006 7:30:21 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP LEG		
Job Number	: 26211C					
Estimate Number	: 10382					
P.O. Number	: N/A			Part Number	: D30655	
This Issue	: 3/13/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D3065 REV. A2	
First Issue	: N/A		Type	: SMALL /MED FAB		
Previous Run	: 24408C			Project Number	: N/A	
Written By	: See comment below			Drawing Revision	: A2	
Checked & Approved By	: JF 06.03.13			Material	: N/A	
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF			Due Date	: 3/30/2006	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S080	5052-H32 .080 Sheet



Comment: Qty.: 1.1338 sf(s)/Unit Total : 136.0548 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.080" thick
(M5052H32S.080)Batch: M100742 4X8 M10012 4X8
M100682 4X8

06.05.09

(120)

2.0 SHEAR

SHEAR



Comment: SHEAR

Cut blank: 16.61" x 8.51" Grain along 8.51"

3.0 HAAS1 Waterjet

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Cut per Machine as per Folio FA179 and Dwg D3065
Stack of 10
Identify as D3065-5Prog Rev: A2
Prog Rev: A2

06.05.09

(120)

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.05.09

(120)

5.0 QC8

SECOND CHECK



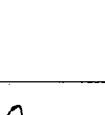
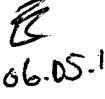
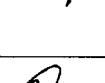
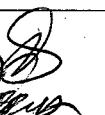
Comment: SECOND CHECK

06.05.15

(111)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-13	3	Dim for slot .213 .213 is under by .003, on a +.005 -0.0 tolerance.	 	Slot is acceptable. Mark for rework.	 06-05-15	 06-05-15	 06-05-13	 06-05-13
06-05-15	3	10 parts scrup. G with hole damage from water jet cutting over the ribs on the back, G with blowouts in the hole causing delamination of mat'l.	 	Scrub & destroy	 06-05-15	 06-05-15	 06-05-15	 06-05-15
06-06-07	5	Holes found few small off Spec D3065-5. .125 roughly .002 .002 → .003 under size.	 	Open manually AS necessary and debur, touch-up holes with solderline AS per QSI 00541.	H.M 06/06/07	 06-06-07	 06-06-07	 06-06-07

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 26211C

Part Number: D30655

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

H.M 06/05/17
(III)

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 06/05/24
H.M 06/05/24
*(IV)
(III)*

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT CHEMICAL CONVERSION COAT

S8 06/05/05
161

10.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *LS-A*

S8 06/06/05
161

11.0	DC	DOCUMENT CONTROL
------	----	------------------



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/06/08
(VI)

Job Completion



w 06/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	26211C
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	01-05-19	Date:	05-05-15	Date:	N/A

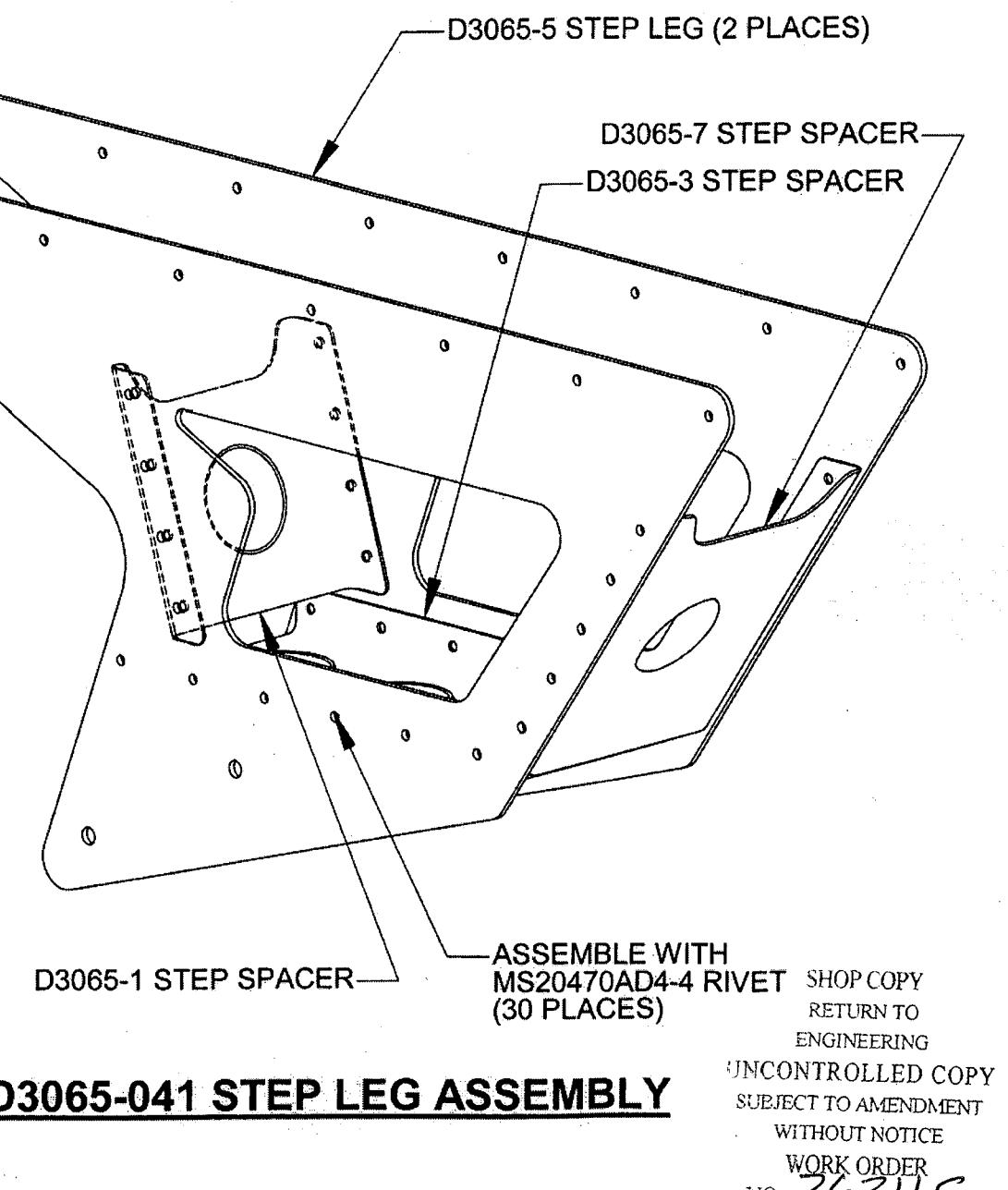
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065 REV. A SHEET 1 OF 5
DATE	02.09.11	TITLE STEP LEG ASSEMBLY SCALE 1:2

RELEASED
02.09.20 *[Signature]*

A	02.09.11	NEW ISSUE
A1	03.02.13 <i>[Signature]</i>	ADD SLOTS TO D3065-5
A2	03.02.27 <i>[Signature]</i>	0.551 WAS 0.410



COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



02.09.11
COPY ISSUED

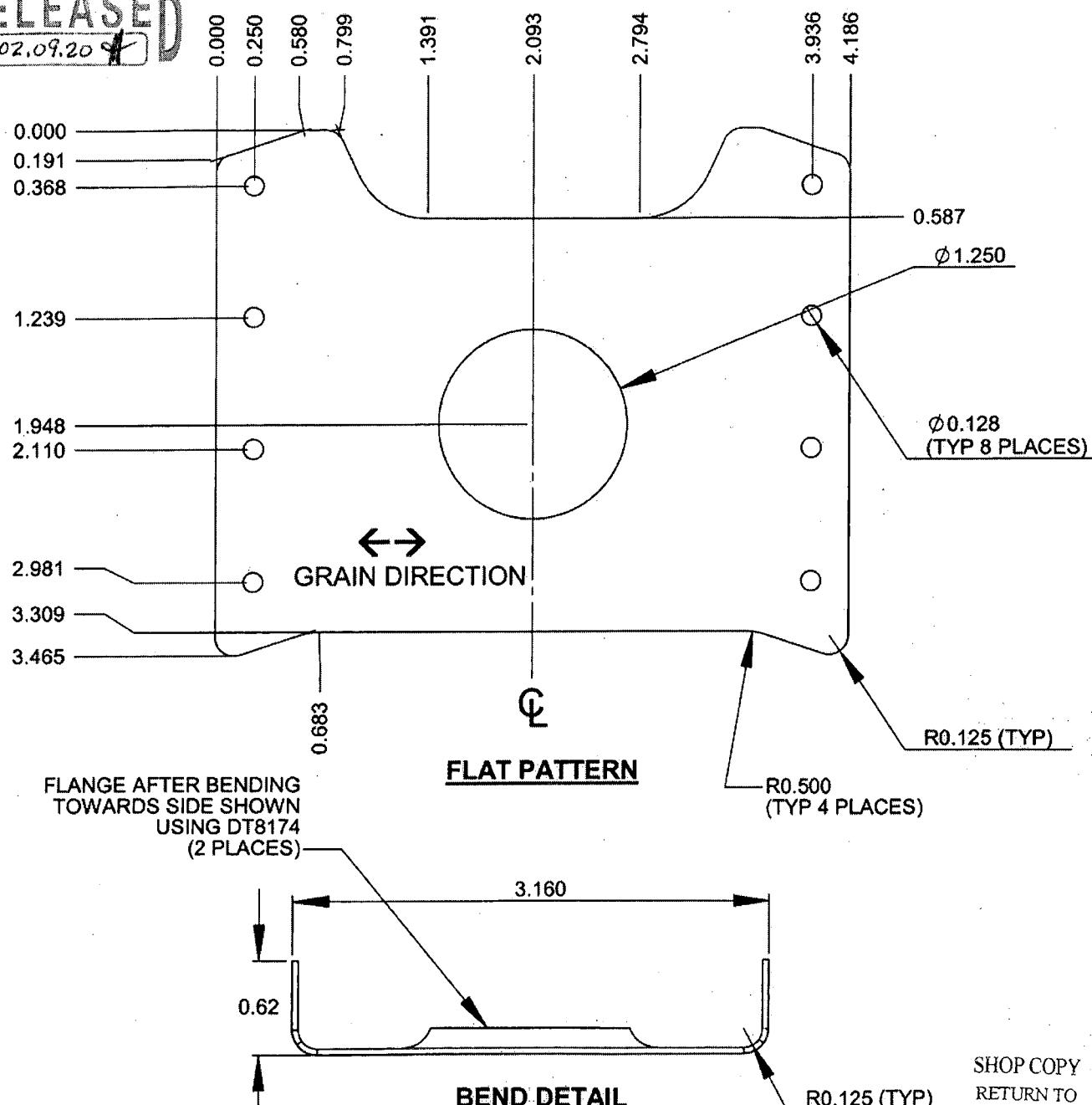
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	02.09.11	TITLE	STEP LEG ASSEMBLY

SHEET 2 OF 5

SCALE

1:1

RELEASED
02.09.2011



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26211C

COPYRIGHT © 200 BY DART AEROSPACE LTD.

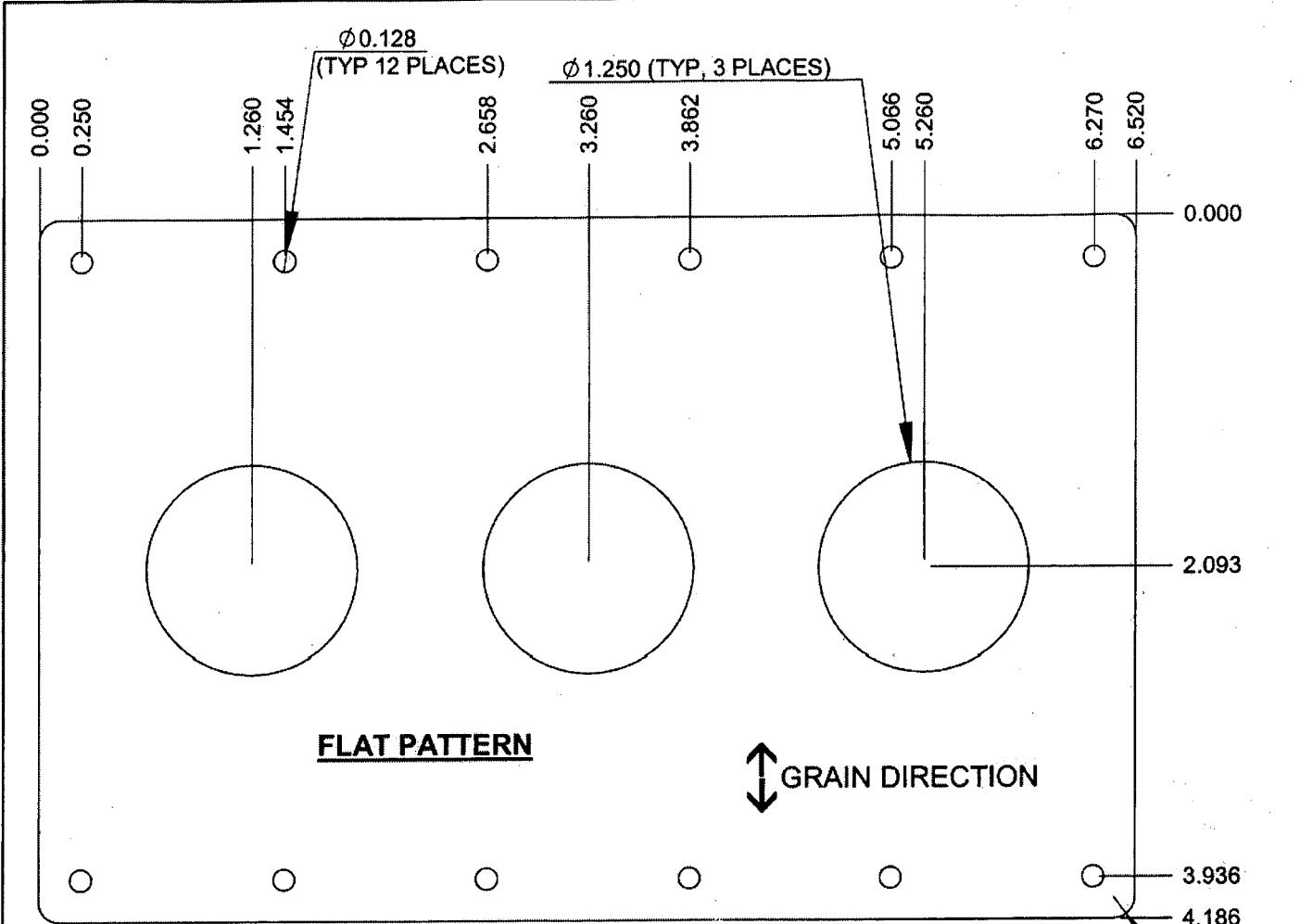
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
02.09.20

DART



DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065
DATE 02.09.11	TITLE STEP LEG ASSEMBLY	REV. A SHEET 3 OF 5 SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

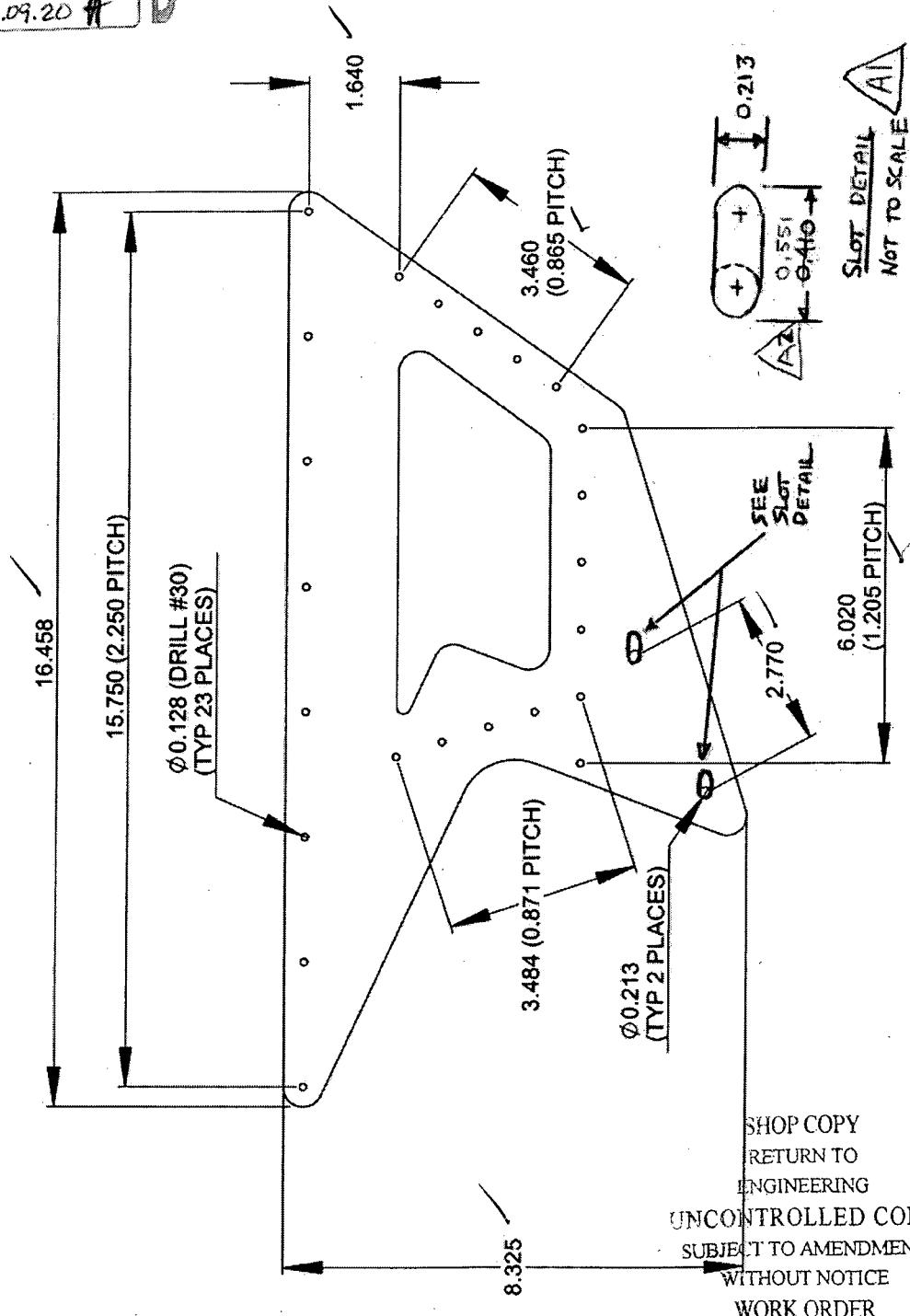
SHOT COPY
R0.125 RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26211C

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3065	REV. A SHEET 4 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY	SCALE 1:3	

RELEASED
02.09.20 *A*

- D3065-5 STEP LEG**
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 - 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005.4.1
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

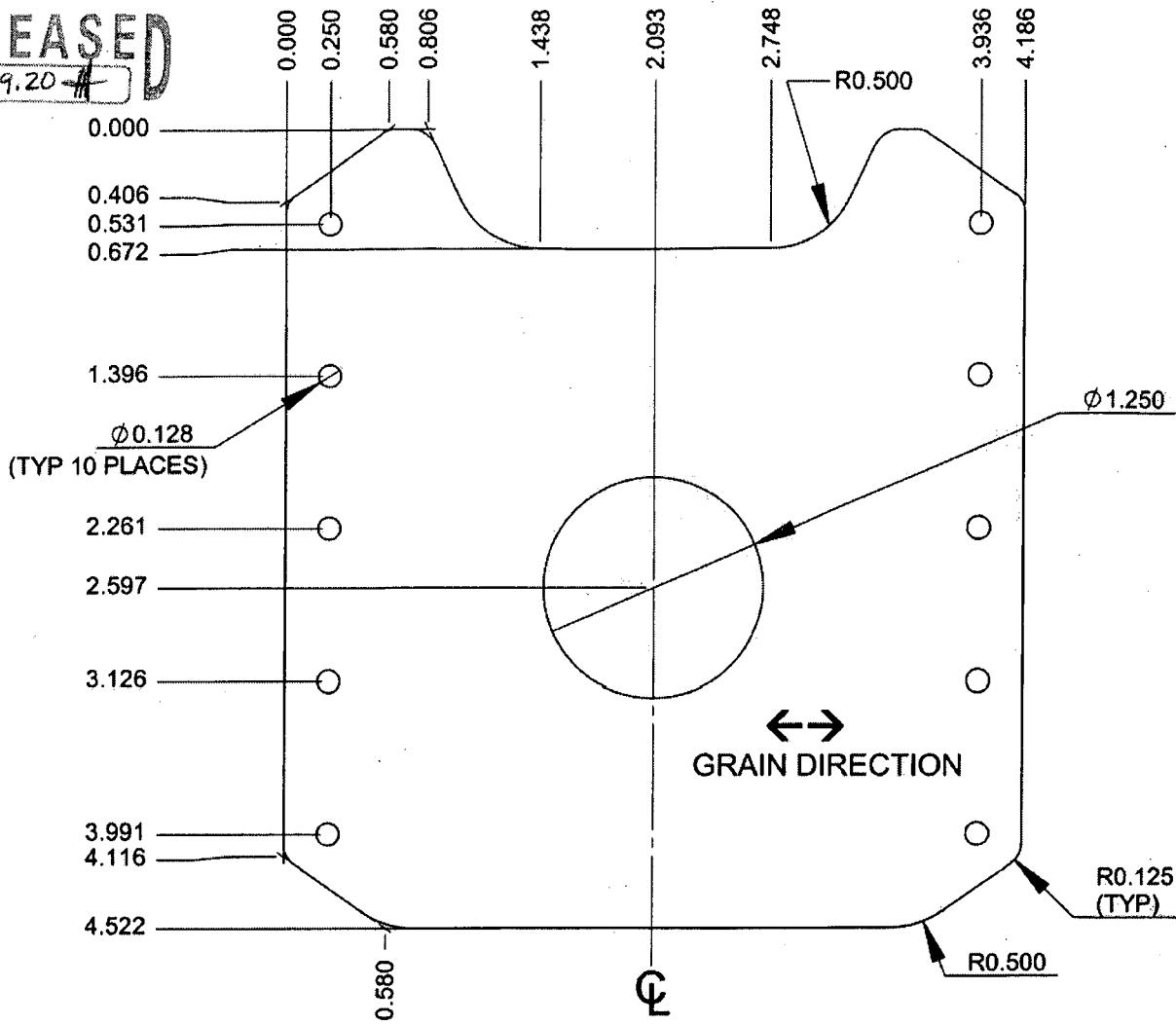
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



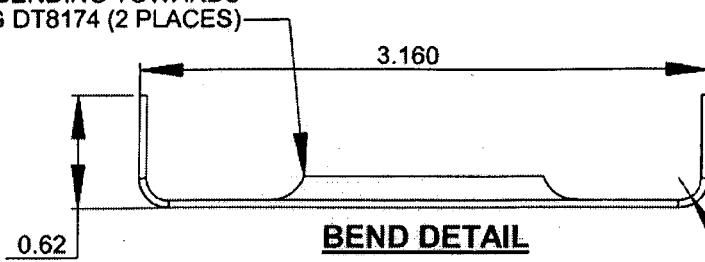
A circular stamp with the words "COPY ISSUED" and "DA" arranged in a circle.

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3065	REV. A	SHEET 5 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY	SCALE 1:1		

RELEASER
02.09.20 - #



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)



FLAT PATTERN

BEND DETAIL

SHOP COPY
R0.125 (TYR)

UNCONTROLLED COPY
TS 3040
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26211C

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M20)
 - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 3) PART IS SYMMETRIC ABOUT CENTERLINE
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT ©2002 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.